

Date: Wednesday, 28/11/2007 2:45:11 PM
 User: Linda Lacelle

Process Sheet

split
 SS 07/12/26

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HELI-ACCESS STEP LH (FOLDING)
 Job Number : 33998 -1
 Estimate Number : 12567
 P.O. Number : N/A Part Number : D412630033
 This Issue : 28/11/2007 S.O. No. : N/A Drawing Number : IIN UNDER REVIEW
 Prsht Rev. : NC Project Number : N/A
 First Issue : 16/08/2007 Type : LARGE FAB ASSY Drawing Revision : K
 Previous Run : 33576 Material : N/A
 Due Date : 05/09/2007 Qty: 5 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est. Rev. A New Issue 06-11-08 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-033 CHG002

08/12/10

2.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	

Batch

33355

08/12/27

3.0 D2803041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2803-041	Bracket Assembly LH	

Batch

029391

07/12/27

4.0 D2804041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2804-041	Bracket Assembly LH	

Batch

0324022

07/12/27

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 33998

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation: Description:

5.0 D2807 Gas Spring (Support Prop)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Support Prop

Pick:

Qty	Part Number	Description
2	D2807	Gas Spring -041

Batch

35962

* WITH INITIAL, REVERSE
ORIENTATION OF GAS SPRING *

6.0 D2813 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch

332238

7.0 D3562041 STEP ASSEMBLY, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description
1	D3562-041	Step Weldment LH

Batch

B 35621

07/12/27

5

8.0 D33951 Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description
4	D3395-1	Bushing

Batch

B33555

07/12/27

5

9.0 AN3C21A BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description
2	AN3C21A	Bolt

Batch

BOLT

07/12/27

5

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 33998

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M10481

AS 02/17/21

(25)

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M105202

AS 07/12/22

(25)

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M105390

AS 07/12/22

(25)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M104929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON

BATCH: M12045

SAD 07-12-28

(2)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-12-31 (2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 33998

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-1

Bushing

B 33590

JS 2/12/27

(X2)

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-3

Bushing

B26160 2X B 27286 2X / 08/01/10

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2810-5

Strut

B32775 X3

B35829 (X2)

JS 2/12/27

(X5)

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3396-1

Spacer

B29496 X4

B34025 X2

JS 7/12/27

(X5)

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

M105793

M105793

JS 7/12/27

(X5)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 33998

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0 AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description
1 AN4C10A Bolt

Batch

M101189

2

AS 02/12/27

27.0 AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description
2 AN4C15A Bolt

Batch

M103915

2

AS 02/12/27

28.0 AN4C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number Description
1 AN4C7A Eyebolt

Batch

M101711

2

AS 02/12/27

29.0 AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number Description
2 AN5C15A Bolt

Batch

M105125

4X

2

AS 02/12/27

30.0 NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number Description
7 NAS1515H4 Washer

Batch

M105516

2

AS 02/12/27

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 33998

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)
Washer

Pick: Packing Kit

Qty Part Number Description
7 NAS1515H5 Washer

Batch

M105792

PCD

AS 07/12/27 (X5)

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)
Nut

Pick: Packing Kit

Qty Part Number Description
4 MS21043-4 Nut

Batch

M106421

PCD

AS 07/12/27 (X5)

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)
Nut

Pick: Packing Kit

Qty Part Number Description
3 MS21043-5 Nut

Batch

M105430

PCD

8/01/10 (2)

AS 07/12/27 (X5)

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/01/10

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location: A

PPP Rev: A

8/1/10

50 (2x) R

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2

AD 08/01/11

Job Completion



12 08.01.11

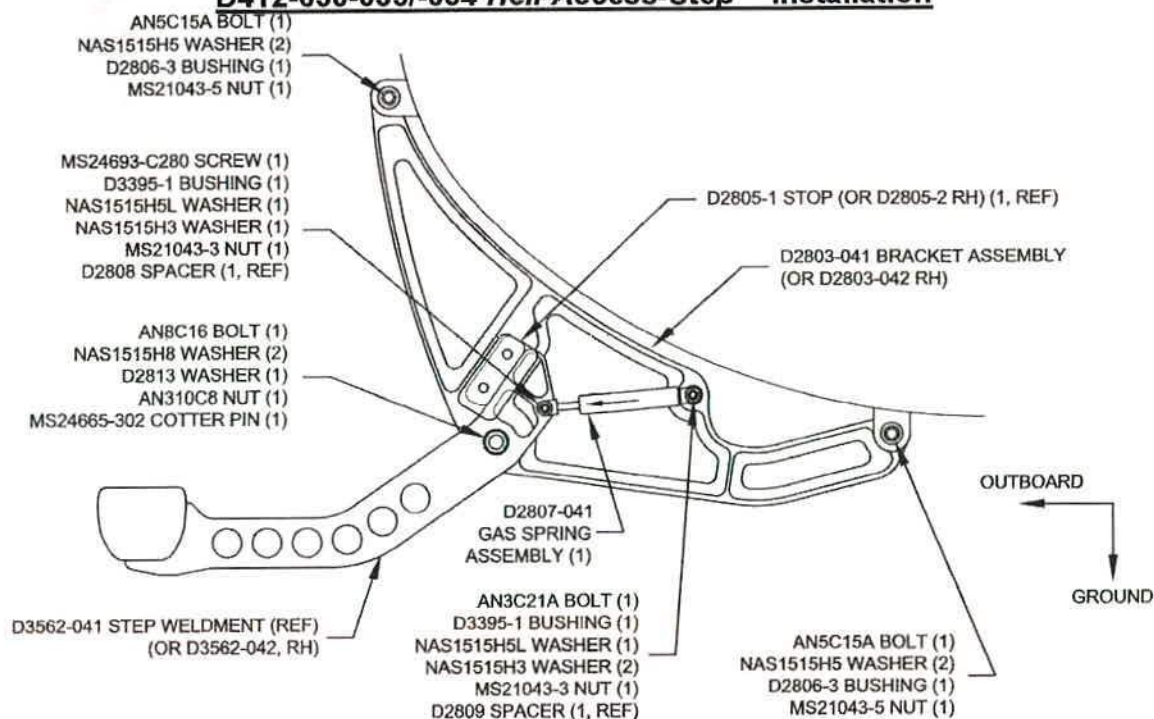
D412-630-033/-034 Heli-Access-Step™ Installation

FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

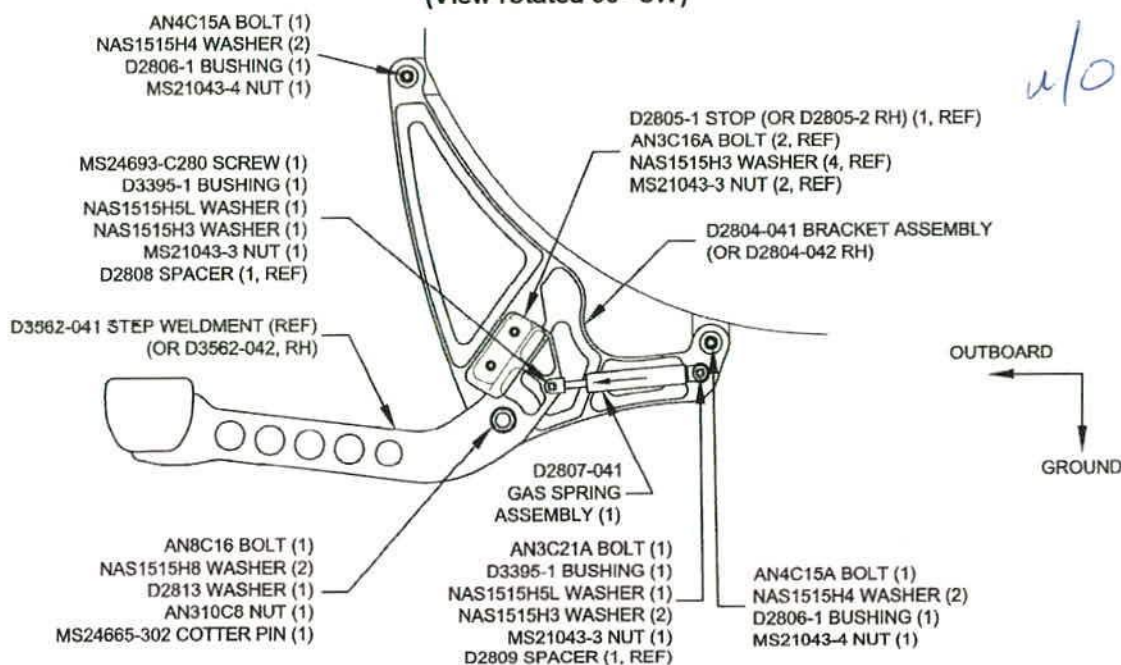


FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

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Revision: **L**
Date: 07.09.30